5/45

DART AEROSPACE LTD.

Work Order: 24433

Description: Saddle Fitting, Fwd (Outboard/Inboard)

Part Number: D2571/D2572

Drawing: D2571 Rev. D/D2572 Rev. D

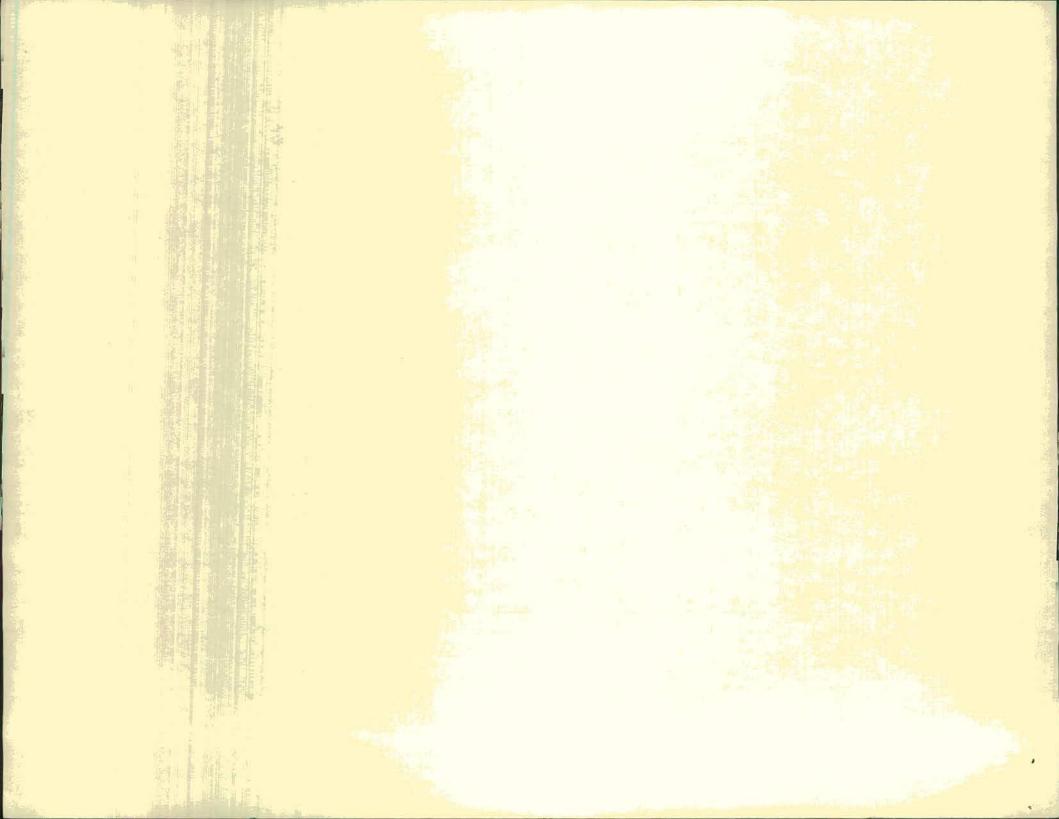
Qty: 8
Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveller Dwg not required	*	05,10,12	8
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: 3 34893	5G	oslialas	8
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: 321817 - A	3.6	05/12/23	00
4/	MV	Fixturing W/O Nø		/NIA/	//
5	MV	Program Batch No. 20033 Double check by:	J.L	05.12.28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	M8/	cudoilo3	w
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	18/	cudoile3	لان
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	181	06/01/03	۶.
9	MV	Machine keyway as per dwg D2571 & D2572	MS	06/01/09	8
10	MV	Deburr and remove all machining marks	MS	Odorle 3	8
11	MV	Tumble for 20 minutes to senore shap edges of oyac 21 N/A	M8	06/01/09	8
12	QC1	Inspect all dimensions to dimension sheets	M8	06/01/09	8
13	QC7	Second inspection	me	04/01/09	2
14	FP	Acid etch and alodine as per QSI 005 4.1	m	06 01 09	2
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	ml	06 01 10	2
16	QC3	Inspect Powder Coat	11	06/01/10	D D
17	ST	Identify and Stock.		06/06/10	2
18	AC	Cost / Part	1	06-0/-1/	2
19	DC	Close W/O Inspection Level 21	0	oslotlu	2

à	Rev	Date	Change	Revised By	Approved
4	G	01.04.27	Added D6101-007 & step 8	EC -	1
	Н	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
	1	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	X\



文 15.07.07



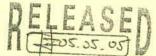
DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. D		Page 1 of 1

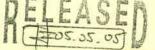
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

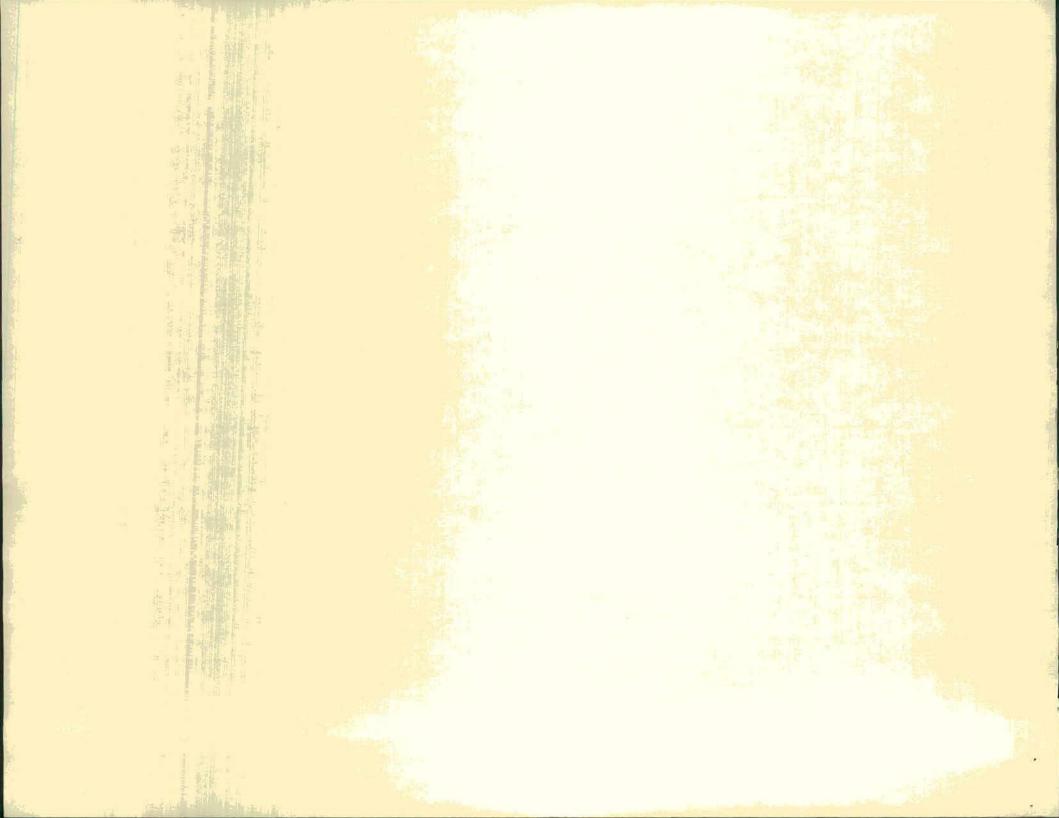
				Re	corded Actu	ial Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1/	2	3	4	Ву	Date
Α	0.438	0.443	DT8682				1		
В	1.745	1.755		1.750	1.749	1,750	1.752		
С	3.495	3.505		3.500	1,700	3.501	3.504		
D	1.745	1.755		1.750	1.747	1.750	1.750		
E	7.990	8.010		8.002	X.000	6.010	8000		
F	0.490	0.510		.501	.500	.507	.500		
G	0.257	0.262	DT8683	1/	11		1		
H	0.375	0.380	DT8684		1	V	1/		
1	0.490	0.510		-500	. 499	.498	.497		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		-568	566	,565	-568		
L	1.174	1.184	11	1179	1.174	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.494	1,495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
0	3.869	3.879		3.874	3-874	3.875	3.872		SII
P	0.115	0.135		-128	-128	-126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		-254	-253	249	-555		
S	0.115	0.135		-126	-128		.132		
T	0.178	0.198		1188	-188	188	-188		
U	2.940	2.980		2-961	2.96	2,962	2.962		
V	0.230	0.250		240	- 241	-247	.248		
W	0.115	0.135		-118	125	2125	.127		
X	0.308	0.313		, 312	.312	312	· 313		
Y	0.760	0.765		.760	.760	.760	760		
Z	0.352	0.372		362	-362	,365	.364		
AA	0.470	0.530		500	- 500	. 500	.500		
AB	0.615	0.635		-627	-627	.639	-638		
AC	0.053	0.073		063	-063	.063	-063		
AD	0.240	0.260		-251	-250	260	.252		
AE	1.375	1.395		7.387	1.388	1,386	1.387		
AF	0.115	0.135		.135	-135	-135	-135		
AG	0.240	0.280		-260	260	.260	-1.13		
AH	0.240	0.260		-255	-252	,254	.245		
Al	2.000	2.020		2.001	2.002	2.002	2.001		
		ept/Reje	ct		4.000	2.00	4.001		
45	0,023			1.030	.030				
	asured by					udited by	me	/	

Measured by: J.L Audited by

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	- 1
D	05.05.05	Added dimension Al	KJ/RF	1







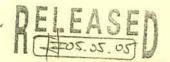
DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. D		Page 1 of 1

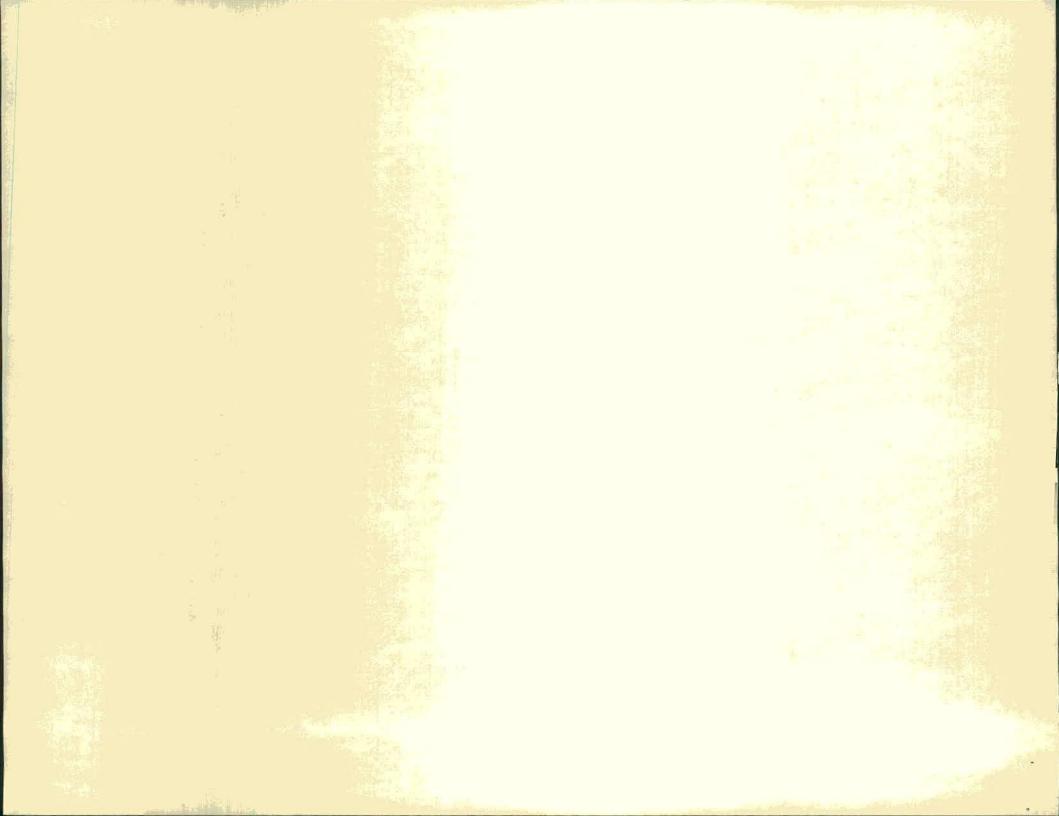
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

		Recorded Actual Dimensions							
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	~	/	/	~		
В	1.745	1.755		1.751	1.751	1.752	1.751		
С	3.495	3.505		3.500		3.500	3.501		
D	1.745	1.755		1.751	1.751	1.751	1.751		
E	7.990	8.010		8.002		8.002	8.004		
F	0.490	0.510		,499	399.	Mad	4-19		
G	0.257	0.262	DT8683	~					
Н	0.375	0.380	DT8684	~	V	V	~		
1	0.490	0.510		-504	£02.	.500	.scc		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		,545	-569	.572	.573		
L	1.174	1.184		1.180		1.179	1.180		
M	1.490	1.500		1.496	1.493	1.494	1.494	3	
N	2.495	2.505		2.501	2.500	2500	2.499		
0	3.869	3.879		3.812	158.8	3812	3.872		
P	0.115	0.135		:127	3510	.120	130		
Q	0.115	0.135		.128	135	.132	-130		
R	0.240	0.260		- 349	.248	255	.257		
S	0.115	0.135		.129	127	(38)	.137		
T	0.178	0.198		185	331.	. 188	381.		
U	2.940	2.980		2.961	2.962	2.964	2.963		
V	0.230	0.250		2241	- 244	-244	,245		
W	0.115	0.135		,128	,130	,130	-127		
X	0.308	0.313							
Y	0.760	0.765							
Z	0.352	0.372		,362	.362	362	.363		
AA	0.470	0.530		500	.500		.500		
AB	0.615	0.635		.628	.628		.628		
AC	0.053	0.073		.C63	.063	,063	.063		
AD	0.240	0.260		-249	250	250	.250		
AE	1.375	1.395		1,383		1.384	1.385		
AF	0.115	0.135		134	,135	,135	,130		
AG	0.240	0.280		270	. 269	, 258	242		
AH	0.240	0.260		,249	, 250	.253	. 254		
AI	2.000	2.020		2.000	2.000		2.000		
		ept/Reje	ct	2.001					
AJ		10.043			1	1	1	1	/
		y: M			A	udited by	Ter	1	
	Date		101/03			Date:		101/09	
					I I		- 0		

Pov	Date	Change		Pavisad by	Annroyed
	Date:	06/01/03	Date:	06/01/0	09
Meas	sured by:	MS	Audited by	Tent	
		0 10 1			

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	-2





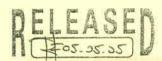
DART AEROSPACE LTD	Work Order:	24433
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. D	*	Page 1 of 1

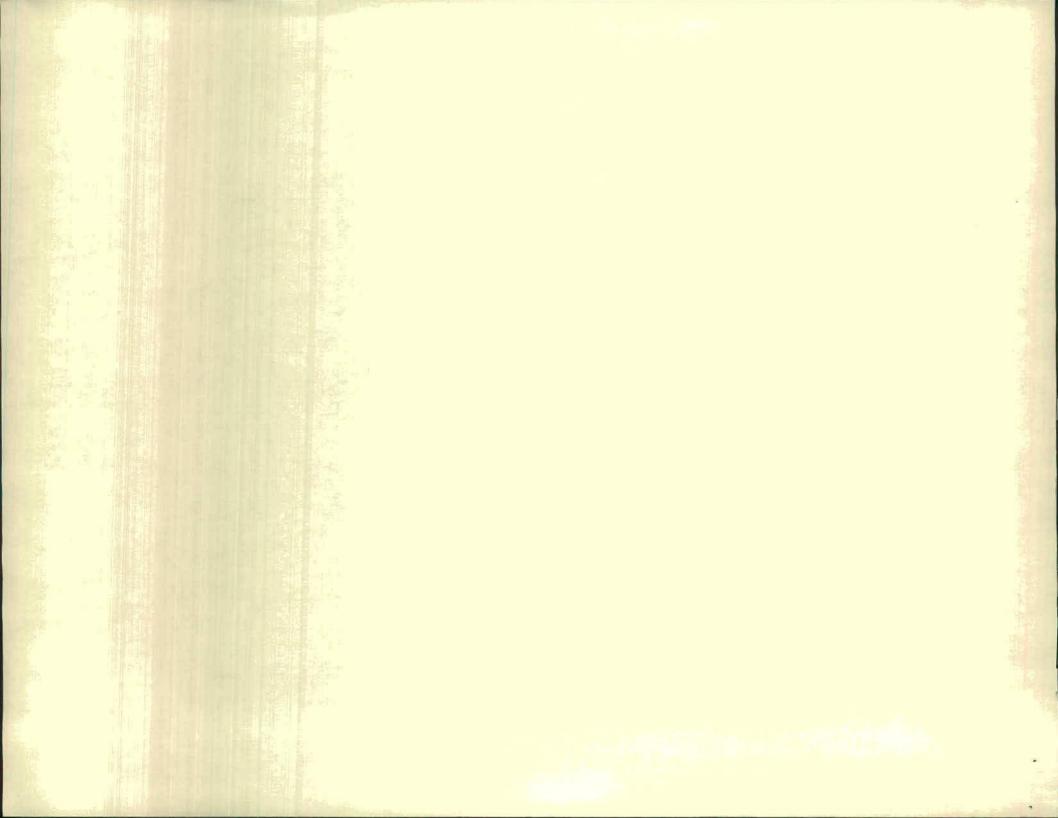
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

			•	Re	corded Act	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682			~			
В	1.745	1.755		1-750	1.750	1750	1.751		
С	3.495	3.505		3.500	3.500	3.500	3.503		
D	1.745	1.755		1750	1.749	1.750	1,751		
E	7.990	8.010		8.001	7.998	1,991	8.005		
F	0.490	0.510		-500	-498	.498	. 500		
G	0.257	0.262	DT8683	11	11		1		
Н	0.375	0.380	DT8684						
1	0.490	0.510		. 500	.498	.497	499		
J	1.174	1.184		1.179	1.179	1.181	1,180		
K	0.558	0.578		. 568		.569	,568		
L	1.174	1.184		1.180	1.179	10179	1,180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.501	2.502	2.500		
0	3.869	3.879		3-874	3.874	3.873	3.872		
P	0.115	0.135		126	-125	-126	-120		
Q	0.115	0.135		135	-135	-135	.135		
R	0.240	0.260		-252	253	-250	.256		
S	0.115	0.135		124	124	T51.	-12C		
T	0.178	0.198		-188	-124	-188	-188		
U	2.940	2.980		2.961	2.962	2962	2964		
V	0.230	0.250		- 240	-237	.241	.239		
W	0.115	0.135		.130	-127	1812	-129		
X	0.307	0.312		.312	.312	-313	,312		
Y	0.760	0.765			.700	02r.	.762		
Z	0.352	0.372		-358	-361	.362	.362		
AA	0.470	0.530		. 500	500	-500	-500		
AB	0.615	0.635		-626	-627	1628	,630		
AC	0.053	0.073		-063	.063	-063	.063		
AD	0.240	0.260		.247	.247	.250	-251		
AE	1.375	1.395		1.388	1.388	1.387	1.390		
AF	0.115	0.135		-135	-135	-135	,135		
AG	0.240	0.280		-260	. 265	. 248	-2115		
AH	0.240	0.260		. 247	-251	249	.254		
Al	2.000	2.020			cant	mester	0		
	Ac	cept/Reje	ct			2.005	2.000		
A.3						.030	.030		
Me	asured b	y: J.L			A	udited by	m	7	

Measured by: JL	Audited by	m		
Date: 05.12.28	Date:	06/01/09		
Rev Date Change		Revised by	Approved	

Rev	Date	Change	Revised by	Approved
А		New Issue	RF	4
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1





DART AEROSPACE LTD	Work Order:	2443
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

		Max	Go/No Go Gauge	Recorded Actual Dimensions					
Dim	Min			1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	/		L			
В	1.745	1.755		1.751	1.752	1.751	1.752		
C	3.495	3.505		3,502	3.502	3500	3.500		
D	1.745	1.755		1.751	1.751	1.751	1,752		
E	7.990	8.010		0000	8.001	8,000	8.005		
F	0.490	0.510		.505	.506	.500	-501		
G	0.257	0.262	DT8683	~					
Н	0.375	0.380	DT8684	V	V		/		
1	0.490	0.510		503	. 500	SCC	500		
J	1.174	1.184		1,178	1,178	1.120	1.179		
K	0.558	0.578		,572	.571	.572	.572		
L	1.174	1.184		1178	1.178	1.19.0	1-179		
M	1.490	1.500		1.494	1.495	1-495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
0	3.869	3.879		3.871	3.870	3.500	3.820		
P	0.115	0.135		3138	121	128	. 128		
Q	0.115	0.135		134	.135	.135	. 135		
	0.113	0.260		,254	-35H	255	254		
R	0.115	0.135		.125	-125	.127	126		
S	0.178	0.198		188	.188	188	381,		
U	2.940	2.980		2.961	2.962	2.962	2.965		
V	0.230	0.250		240	. 240	. 240	645.		
W	0.230	0.236		-126	135	. 127	-127		
		0.133		-100	1,403				
X	0.307	0.765							
Z	0.760	0.763		.363	.363	,363	364		
	_	0.530		.500	.500	SCC	,500		
AA	0.470	0.635		,,,,,,,					
AB		0.033		.063	1063	.063	.063		
AC	0.053	The second second			.249	255	.256		
AD	0.240	0.260		1.388	1.388	1.387	1.388		
AE	1.375	1.395		132	1.300	120	129		
AF	0.115	0.135			,245	1247	. 246		
AG	0.240	0.280		,248	. 320	. 250	. 250		
AH	0.240	0.260		.251	5.001	2.000	2.001		
Al	2.000	2.020 cept/Rej		5.005	2.001	2.00			

- PEAN		- N. 7
Measured by: M\$	Audited by	The
	Date:	21/21/20
Date: 0(0/01/03	Date.	06761164

Davi	Date	Change	Revised by	Approved
Rev	Date		RF	
Α		New Issue	KJ	
В	02.09.24	Re-format; Added Rev. D		
C	02.10.11	Re-format, Added DT8682, DT8683, DT8684	KJ	-15
D	05.05.05	Added dimension Al	KJ/RF	1

